

HipRasp

A26-200

Based on 3D-Models, the wheelpaths can automatically be generated through a meshintersector programm. On the 4 different sides of the rasp 2 sets of inclined sections are ground using a 60 or 70 degrees 1V1 wheel. In order to maintain the shape of the finishing wheel, a preroughing and pregrinding cycle is necessary.



1. Cycletime for production

Toolspecifications

Preshaped form with 0.3 mm overmeasure, no theeth

Operations	Profile PreRoughing	Profile Pregrind	Profile finish
Feed [mm/Min]	150	200	250
Power [kW]	1	1	1
Cutting feed [m/s]	32	32	32
Used wheels	2	2	4
Grinding time [s]	2403	1796	1437
Total cycle time	93 Min 56		

The mentioned cycle times are indicative. The material to be ground, other grinding wheels and other coolants can influence the cycle times considerably.

2. Used grinding wheels

Ø75 1V1 or 11V9
B126



Ø75 1V1 or
11V9 B126

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Control: Fanuc 31i

Coolant: Synthetic Oil, pressure 6 - 7 bar

Software: Quinto 5

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